

ABSTRACT

5 A wear amount of a working tool T during the
machining of a workpiece is estimated during the
machining, and a positional command generated in
accordance with a predetermined machining program is
sequentially corrected during the machining based on the
estimated wear amount of the working tool T. The
workpiece W is machined in accordance with the corrected
10 positional command. Also, the wear amount of the working
tool T upon the interruption of the machining operation
is calculated, and the positional command generated in
accordance with the predetermined machining program is
corrected based on the calculated wear amount of the
15 working tool so that a tool edge position of the working
tool T upon the interruption of the machining operation
coincides with the tool edge position of the working tool
T upon the restart of the machining operation when the
machining operation is restarted at a position where the
20 machining operation has been interrupted. The workpiece
is machined in accordance with the corrected positional
command.